

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011685**Date Inspected:** 29-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 1

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 002 located on Traveler Rail Bracket TR2A – PP38. Welder is identified as 219188. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4C – F.

Weld joint # 002 located on Traveler Rail Bracket TR2A – PP40. Welder is identified as 216575. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4C – F.

Weld joint # 002 located on Traveler Rail Bracket TR2A – PP39. Welder is identified as 215397. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4C – F.

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Weld joint # 005 located on Traveler Rail 21TR3 – 004. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

BAY 2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 005 located on Traveler Rail 20TR1 – 016. Welder is identified as 201912. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

Weld joint # 001 located on Traveler Rail 20TR1 – 001. Welder is identified as 201215. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

BAY 5

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 006 located on Traveler Rail Bracket TR5C – PP37. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Liu Fawen. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4C – F.

Weld joint # 006 located on Traveler Rail Bracket TR6B – PP42. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Liu Fawen. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4C – F.

BAY 6

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 001 located on U-rib connection plate USPL1 – 316. Welder is identified as 222396. ZPMC Quality Control (QC) Inspector is identified as Shu Yang Hua. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 002 located on U-rib connection plate USPL1 – 317. Welder is identified as 062447. ZPMC Quality Control (QC) Inspector is identified as Shu Yang Hua. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
